



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5357-041
Job Sheet 169864



Part No: D5357-041

Job Qty: 3 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 2/9/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP REV:A 15.10.28 NEW ISSUE DD VERF:JLM IPP REV:B 17.01.11 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		2/8/18	0.00	0.00	Start Up Large Fab-3		DYC 18/02/20
110	Large Fab	3 pcs		2/8/18	0.00	3.20	Large Fab 1		DYC 18/02/20
120	QC	3 pcs		2/8/18	0.00	0.00	QC9		CPC
130	QC	3 pcs		2/8/18	0.00	0.00	QC5		CPC
140	Small Fab	3 pcs		2/9/18	0.00	1.58	Small Fab-9	5 FEB 21 2018	TF DAS 38
150	QC	3 pcs		2/9/18	0.00	0.00	QC5		38
160	Packaging	3 pcs		2/9/18	0.00	0.00	Packaging3-2	5 FEB 21 2018	9-10 DAS 6
170	QC21-SA	3 Ea		2/9/18	0.00	0.00	QC21		DAS 21 FEB 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4794-3	Stud	6 Ea (2 ea)	90-Start up Operation	
M304TR0.500W.049	304 Round Tube .500 X .049W	6 ft (2 ea)	90-Start up Operation	
AN3C3A	Bolt	6 Ea (2 ea)	140-Small Fab	
AN665-34R	Clevis	6 Ea (2 ea)	140-Small Fab	
D2690-6	Lanyard	6 Ea (2 ea)	140-Small Fab	
MS17984-C405	Pin, Quick Release	6 Ea (2 ea)	140-Small Fab	
MS21043-3	Nut	6 Ea (2 ea)	140-Small Fab	
MS21919WCF8	Clamp	6 Ea (2 ea)	140-Small Fab	
NAS1149C0332R	Washer	12 Ea (4 ea)	140-Small Fab	
NAS509-4C	Nut	6 Ea (2 ea)	140-Small Fab	

601059

Master Unit 001052



Job No 169864



Container No: S043956



Part: D5357 - 041

Job No: 169864

Serial No/Batch: S043956

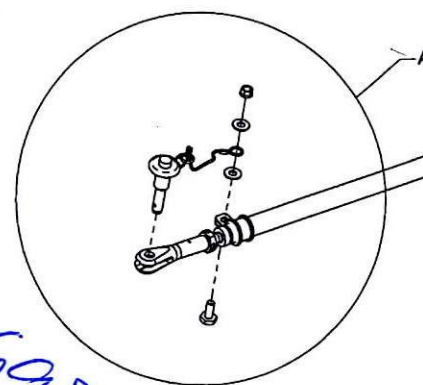
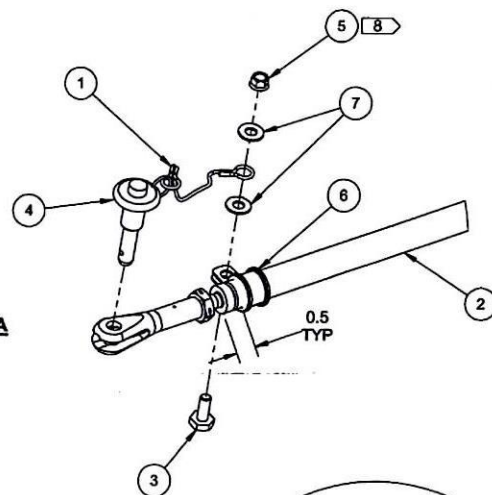
Revision: D5357

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/20/18

DETAIL A



D5357-041 STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.82 lbs
- 8) TORQUE NUTS TO 20-25 in-lb

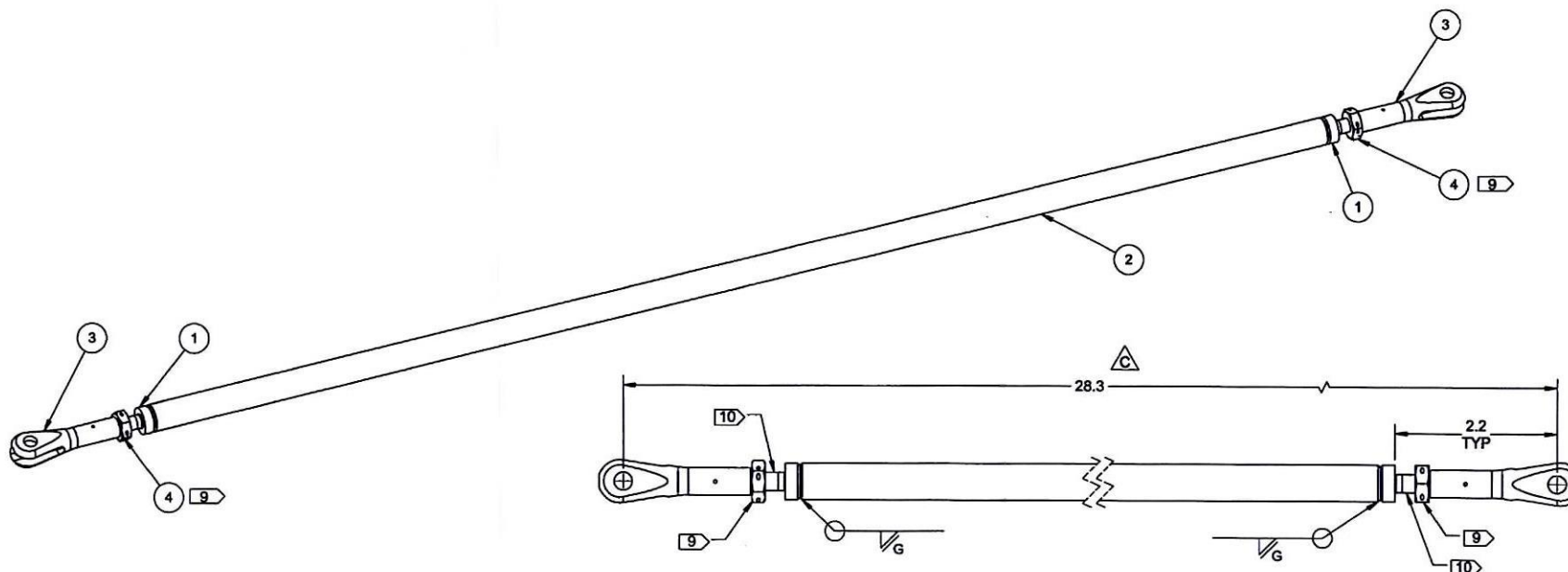
ITEM	QTY	P/N	DESCRIPTION
	X	D5357-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5357-043	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	MS17984-C405	PIN, QUICK RELEASE
5	2	MS21043-3	NUT, SELF-LOCKING
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

C	23.44 WAS 23.83 (ZN C5-3) PER FLIGHT TEST INPUTS	RF	17.02.09
B	28.5 WAS 28.8, 2.2 WAS 2.3, 26.83 WAS 23.92 (ZN C3-2, B1-2, C5-3)	RF	16.12.15
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	DD	D5357	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-03-22
6017-535

APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D5357-043	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5357-1	STRUT
3	2	AN665-34R	THREADED CLEVIS TIE ROD
4	2	NAS509-4C	NUT, JAM



D5357-043 STRUT WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.68 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV. C
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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

0.030 x 45°
CMF, 2 PL

C

23.44



D5357-1 STRUT

Ø0.500
REF

0.049
REF

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 001059

Tel (613) 632-5200

Containers on Master Unit 001059				
Serial No	Part No	Customer Part No	Status	Quantity
S044079	AN3C3A		Allocated	6
S044078	AN665-34R	AN665-34R	Allocated	6
S044077	D2690-6	D2690-6	Allocated	6
S044076	MS17984-C405		Allocated	6
S044075	MS21043-3	MS21043-3	Allocated	6
S027739	MS21919WCF8		Allocated	2
S044074	MS21919WCF8		Allocated	4
S044073	NAS1149C0332R		Allocated	12
S044072	NAS509-4C		Allocated	6